Work Örd March-23-12	er ID 82188 3:01:17 PM	·.	*82	188*							Page
Item ID: Revision ID: Item Name:	D350-636-011 Skidtube LH		Accept	*N900	040	100	)*	Setup	Start Stop	1.71	S1* S2*
Start Date: Required Date Reference:	23/03/2012 Start Qty: 1.00	*1* *1*		Cust Item   Customer:	ID:					IVI	<b>.</b> 7/
Approvals:	Process Plan: MLJ	Date: 12/03/2	3 Tooling:	D	ate:			Run	Start	*N	R1*
	QC:	Date:	SPC (Y/N):	<b>D</b>	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D2750 D3492	F C			ù						and the state of t	
*100 DC	DOCUMENT CONTRO . Memo	ıL	0.00	. <		 اسا	4	Pol	Mı	5 (2	2-4-2
Document Control	Photocopy b	lue file and type labels pe	r PPP D350-636-011 CH	G 006 & B	Dilla	1176				*	•

Dart	<b>Aeros</b>	pace	Ltd
------	--------------	------	-----

W/O:		WORK ORDER CHA	NGES								
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
<del></del>											
			·								

Part No: _	I	PAR #:	Fauit Category:	NCR: Yes No	DQA:	Date:	
	and the second s						
	Resolution:		Disposition:	QA: N/C Closed	l: .	Date:	

NCR:		W	ORK ORDE	ER NON-CONFORMANO	CE (NCR)			
		Description of NC	· ·				Ammental	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
		*						
٠								7.
								<b>₹</b> . 8
	<u> </u>	:					-	
						•		· **
								• .
							, •	
			* 3				. 4	
						-		

0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

Page 2

#### **Dart Aerospace Ltd WORK ORDER CHANGES** W/O: **Approval Approval DATE** STEP **PROCEDURE CHANGE** By Qty Chief Eng / Date QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval** Approval **DATE** STEP Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Chief Eng Chief Eng Date

· Work Ord March-23-12 3		188		*82	188*						Page	3
Item ID: Revision ID:	D350-636-0	11		Accept	*N900	<b>0401</b>	<b>೧</b> ೧*	Setup S	Start	*N	S1*	
Item Name:	Skidtube LH								Stop	*N	S2*	
Start Date:	23/03/2012	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date: Reference:	09/04/2012	Req'd Qty: 1.00	*1*		Customer:							
Approvals:	Process Pla	in:	Date:	Tooling:	Da	ate:		Run	Start	*N	R1*	
						ate:		:	Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Pla		Rejec Qty		eject umber	Insp. Stamp	
		from bendin A/R Alum	744 Cap as per Dwg D27: g as per QSI 004 inum Rod batch: MA	20/64 82	res in bend left / 12/04/02	_2LD	12-09	4/02		-		
120 *170* QC Quality Control		QC10- Inspect visual per  Memo	QS1004- ground welds	0.00 5 17 (	e lez			· -				-
130 *130*		QC5- Inspect part comple	eteness to step on W/O	0.00	<i>^</i>							
QC Quality Control		Memo		<sub>0.00</sub> S(U	10419							

Dart	Aer	ospace	Ltd
------	-----	--------	-----

	- Johnson	<i>-</i>							
W/O:			WC	ORK ORDER CHANGES	3			,	
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
									•
Part No		PAR #:							
···	R	esolution:						Date: _	
NCR:		V	VORK ORDI	ER NON-CONFORMAN	CE (NCI	₹)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section E Action Description Chief Eng	Sign of Date			Approval Chief Eng	Approval QC Inspector

The state of the s

Work Ord		188		*82	188*							Page 4
Item ID: Revision ID: Item Name: Start Date: Required Date	D350-636-0 Skidtube LH 23/03/2012 : 09/04/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	Accept	*N900  Cust Item II Customer:		100	<b>)</b> *	Setup	Start Stop	1 7	S1* S2*
Reference:							_	ī	Run	Start	<b></b>	<b>D</b> 4 #
Approvals:	Process Pla	ın:	_ Date:	Tooling:	Da	ite:		-	Xuii		*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ite:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
140		Chemical Conversion Co	oat per QSI005 4.1	0.00				_ /	n.	^		_
*140* HandFinish Hand Finishing		Memo		0.00	,			M		12	B	3
150		QC3- Inspect Part Finish		0.00								٠.
*150*		Memo		0.00			•	590		12	- 00	1-03

0.00

Memo

Quality Control

Dart Aerospace Ltd	Dart	Aero	ospace	e Ltd
--------------------	------	------	--------	-------

W/O:			WO	RK ORDER CHANGES				· .	•
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				Ψ,					
			24-724 24-724					w.*	
-			"						
:						X			The State of the S
		·						, A	
Part No:		PAR #:	Fault Categ	ory: N	CR: Yes	No DQ	<b>\</b> :	Date: _	
	R	esolution:	Disposition	: Q	A: N/C C	losed:	**************************************	Date: _	
NCR:	11	"	WORK ORDE	R NON-CONFORMANC	CE (NCF	<b>7</b> )			
D.4.77		Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	Section	on C	Chief Eng	QC Inspector
			,				<b>W</b>		
• .							- 3	*	
	,								
··· ,··		÷.					•		
								-	
7.									
		- 1,							
	I		1		- 1				l

Work Order ID 82  March-23-12 3:01:17 PM	2188		*821	88*							Page
Item ID: D350-636-0 Revision ID: Item Name: Skidtube LH Start Date: 23/03/2012	Start Qty: 1.00	*1*	Accept	*N900	ID:	1100	)*	Setup	Start Stop	*N *N	S1* S2*
Required Date: 09/04/2012 Reference:	, Req'd Qty: 1:00	*1*		Customer:							
	an:	Date:	- 0		ate:		ì	Run	Start Stop	*N	R1*
QC:		_ Date:	_ SPC (Y/N):	D	ate:				•	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*160* Skidtubes Skidtubes	side) as per dwg E 2-Open up h as per dwg E 3- Open floa 4-Chamfer h (welding inst 5-Deburr and 6- Prepare tu 7-Bond web A/R Sikat 8- Weld spac (welding inst A/R Alumin 9- At section	oles of Detail B to 0.750" 02750.  t hole to 0.500" (4 per side oles of Detail B, C, ground fructions on sheet 8)  d blow out all chips from the befor welding, remove all D2739 in place as per QS exp.	inside of tube odine as required.  1015 20813 date: 12/08/13 ad D2743 as per dwg D275 2015 4 June 10 10 10 10 10 10 10 10 10 10 10 10 10	per dwg D2750	- 74		B 12	,	03		

Dart Aerospace	Ltd
----------------	-----

Dart Ae	rospace	Ltd				* <		•
W/O:			WO	RK ORDER CHANGE	ES		ı	,
DATE	STEP	PROCEDURE CHANGE				Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA:	Date: _	
Resolution:		solution:	Disposition: Q			osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)		
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description Chief Eng	on B Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B	Verification	Approval	Anneous						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector					
						,							
		*											
			_										
	<u> </u>												
		•											
		i San											
	-												
								-					
			·	*									

Work Ord		2188	*82188*								Page 6		
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube LH	11		Accept		*N90004010			Setup	Start Stop	1.71	S1* S2*	
Start Date: Required Date Reference:	23/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	Cust Item ID: Customer:				-	· N	5/"	
Approvals:				te: Tooling: te: SPC (Y/N):		te:			Run	Start Stop	17	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description  11-Spot fac dwg D2750  12-Deburr h		Set Up/ Run Hour ection (total of 4 place		Tool#	Plan Code	Accep	Qty	, !	Reject Number	Insp. Stamp	
170 *170* QC Quality Control		QC10- Inspect visual per Memo	r QS1004- ground welds	0.00	idaylo							- <del></del> -	
*180 *180*		QC5- Inspect part comple	eteness to step on W/O	0.00	> Mulio								

Quality Control

N/O:		WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	_ Date: _					
	R	esolution:		ion:				Date: _					
NCR:			WORK OR	DER NON-CONFORM	ANCE (NCF	<b>?</b> )							
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	tion B	Verific		Approval	Approval				
		Section A	Chief Eng	Chief Eng	Date		on C	Chief Eng	QC Inspector				
								`					
									,				
			,										
		·											

Work Order ID 82188  March-23-12 3:01:17 PM				*821	88*				Page 7
Revision ID:	D350-636-011  Skidtube LH  23/03/2012 Start Qty: 1.00 e: 09/04/2012 Req'd Qty: 1.00			Accept	*N9000401		<b>೧</b> ೧*	Setup Star	1021
Start Date: Required Date: Reference:			*1* *1*	•		Cust Item ID: Customer:			14.37
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:		Run Star	"NR1"
	<b>QC:</b>		Date:	<b>SPC (Y/N):</b>	Da	ate:		Stop	*NR2*
Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Tool ID		lan Accep	t Reject Qty	Reject Insp. Number Stamp
190		Pressure Wash per QSI00	05 4.3	0.00			1 \1	· 1	MA
*100* HandFinish Hand Finishing		<b>Memo</b> Re-alodine to	ube as per QSI 005 section	0.00 4.1.2.1 do not acid etch.			<u> </u>	_ <i></i>	12/04/
<sup>200</sup> *2∩∩*		White Gloss(Ref:4.3.5.1)	per QSI005 4.3-Alum	0.00			I v	$\mathcal{A}$	m-L
Powdercoat Powder Coating	222	Memo START TIM OVEN TEM FINISH TIM		200 €			l <u>A</u>	<i></i>	
*210 *210* oc		QC7-Inspect Chemical Co	onversion Coat	0.00				6_	BB-4-3

Inspect for foreign object per QSI 024

Quality Control

Dart Aerospace L	_td
------------------	-----

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector				
	!							e.					
Part No	•	PAR #:	Fault Ca	tegory:	_ NCR: Ye	s No	DQA:	_ Date: _					
			Disposition: QA: N/C Closed:										
NCR:			WORK OR	DER NON-CONFORM	ANCE (N	CR)							
DATE	STEP	Description of NC Section A	Initial	Action Description	ection B  n Sign &		Verification Section C	Approval Chief Eng	Approval QC Inspector				
			Chief Eng	Chief Eng	Da	ite		-	<u>'</u>				
						•							
		·											

4.	Work Order ID 82188  March-23-12 3:01:17 PM			*821	188*		* * **********************************	STANDARD OF AS E				Page 8
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube LH	D350-636-011 Skidtube LH		Accept	*N900040100*			ገ*	Setup	Start Stop	*N	S1* S2*
Start Date: Required Date: Reference:	23/03/2012 09/04/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:						IV.	
Approvals:	Process Pla	n:				Pate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	)	Operation Description	· - · <u>-</u>	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Reje Qty		Reject Number	Insp. Stamp
* <b>99</b> 0* HandFinish Hand Finishing		HandFinishing  Memo  I - Install ins	erts as per Dwg D2750	0.00			L <sub>t</sub>	+	<b>*</b>			12/04/23
230 *230*		HandFinishing		0.00				j	8	S i	(D)	(404/25
HandFinish Hand Finishing			Foreign Objects le of tube with "LPS-3	0.00 " batch: <b>///</b>				4				<del>* ( * (</del>
		per dwg D27 SIKA FLEX BATCH:/ EXP DATE:_ 4-assemble o'	50 241 <u>7[ 22 ]</u> 	wearshoes and ground handling by the standard ground ground handling by the standard ground g								

5-Coat all exposed fasteners with "LPS Procyon" batch: 114596

W/O:			W	ORK ORDER CHANG	ES				,	•		
DATE	STEP	PR	OCEDURE CHA	NGE	I	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
										*		
Part No: PAR #: _			Fault Cate	gory:	_ NCR:	Yes I	No DQ	A:	_ Date: _	Date:		
	Resolution:		Dispositio	n:	_ QA: N	VC Clo	sed:		Date: _			
NCR:		· · · .	WORK ORD	ER NON-CONFORMA	ANCE (	NCR)	)					
DATE	STEP	Description of NC	A-siai al	Corrective Action Section		Sign &	Verific		Approval	Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Section	on C	Chief Eng	QC Inspector		
			,									

T:	<b>Work Order ID 82188</b> March-23-12 3:01:17 PM			*82188*							Page 9		
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube LH	11		Accept	*N900	0040	10	<b>N</b> *	Setup	Start Stop	1 <b>U</b>	S1* S2*	
Start Date: Required Date: Reference:	23/03/2012 : 09/04/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item : Customer:								
Approvals:		in:				ate:	· · · · · · · · · · · · · · · · · · ·		Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II 240 *240* QC Quality Control	<b>D</b>	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours 0.00  0.00  17/4	Tool ID	Tool#	Plan Code	Accep Qty	Qty		Reject Number	Insp. Stamp	
250 * <b>250</b> Packaging Packaging		Pick Kit <b>Memo</b>		0.00						-		12/04/2	
260 <b>*260*</b> QC Quality Control		QC4- 100% Inspect kits t  Memo  ******ensur	for completeness e antiseize is on AN8C21	0.00 0.00	orlate			(A	<del>)</del>				

W/O:		· · · · · · · · · · · · · · · · · · ·	W	ORK ORDER CHANG	ES			,	,				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC inspector				
									•				
		PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQ</b>	<b>A:</b>	Date:					
	Re	esolution:	Dispositio	n:	_ QA: N/C CI	osed:		Date: _					
NCR:			WORK ORDER NON-CONFORMANCE (NCR)  Corrective Action Section B										
DATE	STEP	Description of NC		on B	Verific	ation	Approval	Approval					
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector				
								,					

Work Order ID 82188  March-23-12 3:01:17 PM				*82 <i>*</i>	·		Page 10			
Item ID: Revision ID:	D350-636-0	11		Accept	*N900	<u>104</u> 0	110	<b>N</b> *	Setup Sta	14771
Item Name:	Skidtube LH								Sto	<sup>p</sup> *NS2*
Start Date:	23/03/2012	Start Qty: 1.00	*1*		Cust Item	ID:				
Required Date	e: 09/04/2012	<b>Req'd Qty:</b> 1.00	*1*		Customer:					
Reference:										
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:		J	Run Sta	"NR1"
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	*NR2*
Sequence ID/ Work Center 1	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
*270*		Packaging		0.00						(2/1/26)
Packaging		Memo		0.00				CD		12141251
Packaging		Package as p	per PPP D350-636-011	Rev. 1						1
280		QC21- Final Inspection -	Work Order Release	0.00					ر م	1 Inland X
*280* QC Quality Control		Memo		0.00					121	4/2608

MF 12-04-26

Dail Aciospace Liu									
W/O:			WC	RK ORDER CHANG	ES			, •	
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	<b>.</b>	PAR #:	Fault Cate	jory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	Re	esolution:	Disposition	);	_ QA: N/C C	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCF	<b>?</b> )			
		Description of NC		Corrective Action Section	on B	Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
•									

### **Picklist Print**

· March-23-12 3:01:20 PM

Work Order ID: 82188

D350-636-011

\*82188\*

Parent Item Name: Skidtube LH

\*D350-636-011\*

**Start Date:** 23/03/2012

**Required Date:** 09/04/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

Parent Item:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ IPP Rev:J 06-03-23 As per Rev D JLM

IPP Rev:K 06-07.13 As per dsi9343 EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC

IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010

DD verf:EC seq110

IPP Rev:P 10.06.22 revise

DD verf:EC

DD verf:EC	IPP Rev:Q	10.10.01	as per IIN revI-
arf.EC			•

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seg ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3492-1		Manufactured	No		,	230	Each	94.0000	8	8		
*D3492-1*									**	8	(P)	12/04/21
				Location	93'09SV	Loc (	<u>Oty</u>	Loc Code				
				FP002			94				_	
					69531		8				_	
					74444		2					
					76235		4				_	
					77037		80				_	
D3492-3		Manufactured	No			230	Each	33.0000	8	8		
*D3492-3*									**	2_		12/04/6
				Location		Loc C	<u> Dty</u>	Loc Code				. /
				FP-A			33					

33 33

Dark Molecupado Eta													
W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _					
Resolution:		solution:	Disposition	n:	QA: N/C C	losed:		Date: _					
NCR:		1	WORK ORDI	ER NON-CONFORMA	NCE (NCI	₹)							
	Γ	Description of NC		Corrective Action Section	n B	Verifi	cation	Annroyal	Annroyal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	& Secti	ion C	Approval Chief Eng	Approval QC Inspector				
·													

fr.j

Picklist Print  March-23-12 3:01:21 PM										Page 2
Work Order ID: 82188		*A	2188*							
Parent Item: D350-636-011 Parent Item Name: Skidtube LH			)350-636-0 <i>°</i>	11*			art Date: tart Qty:	23/03/2012 1.00	Required Date: 09 Required Qty: 1.	
NAS1611-010	Purchased	No		230	Each	173.0000	8	8		
*NAS1611-010*							**	_8_	1400	1/21
	,		Location  FP   120986     110915     120770     FP001     110915     117460     118077     118612     119438     120986     12144		50 0 50 123 14 8 1 3 47 50	<u>Loc Code</u>		4	      	)
NAS1149D0863J	Purchased	No	12/166	250	Each	227.0000	2	2		,
*NAS1149D0863	.1*						**		J 3	17/64/23
			<u>Location</u> ST298 118078 119307 120308	<u>Lo</u>	227 36 91 100	Loc Code		11930	<u> </u>	
D2744 <b>*D2744*</b> Cap	Manufactured	No		110	Each	55.0000	i **	1	BE1	2/04/02
			Location	Loc	e Oty	Loc Code				
			LG002 62715 70881 71861 78900		55 1 9 3 42			<u> </u>	- - - -	

Dail Mei	Ospace	s Liu							-							
W/O:			ES				•									
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
								·	,							
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _								
	R	esolution:	Disposition	l:	_ QA: N/C C	losed:		Date: _								
NCR:			WORK ORDER NON-CONFORMANCE (NCR)													
		Description of NC		Corrective Action Sect	ion B	Approval	Approval									
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	cation tion C	Chief Eng	QC Inspector							

Picklist Print  March-23-12 3:01:21 PM									Page 3
Work Order ID: 82188		*8	2188*						
Parent Item: D350-636-011  Parent Item Name: Skidtube LH			)350-636-0	11*			Start Da Start Q	te: 23/03/2012 ty: 1.00	Required Date: 09/04/2012 Required Qty: 1.00
D2600-3-BENT	Manufactured	No		110	Each	15.000		1 1	
*D2600-3-RFNT*							**		B 12/04/01 X
			Location 8234	7	oc Qty	Loc Coc	<u>le</u>		ι · ι
			LG		15				_
			66875 73253		7 1				<u> </u>
			75021		1				<del>-</del>
			75022		1				<del></del>
			75023 81330		1				<u> </u>
D2743	Manufactured	No	81330	160	4 Each	208.000	00	8 8	<del>_</del>
*D2743* Crossbolt Spacer	wanulactured	110		100	Lacii	208.000	**	8 8	BE12/04/04
			Location	· <u>L</u> c	oc Oty	Loc Cod	<u>e</u>		/
-			LG001		208				
			67766		4				_
			68251 73403		3				_
			73403 74445		64 1				<del>-</del> .
			78603		36				_
			79517		100			8	_
D2739	Manufactured	No		160	Each	10.0000		1 1	
*D2739* 3501Beam							**		B 12/04/or
			<b>Location</b>	<u>Lo</u>	c Oty	Loc Code	<u>:</u>		/
			LG		10				_
			72155		1				<del>-</del>
			81508		9				_

W/O:		WORK ORDER CHANGES													
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
									•						
					i i		-								
Part No	:	PAR #:	Fault Cat	egory:	NCR: Y	NCR: Yes No DQA: Date:									
Resolution:			Dispositi	on:	QA: N/C	Closed	:	Date: _							
NCR:	·		WORK ORE	DER NON-CONFORM	ANCE (N	CR)									
DATE STEP		Description of NC	E. tat - I		ction B	ın & V	erification	Approval	Approval						
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		ate	Section C	Chief Eng	QC Inspector						
							•								
······································		·													

Picklist Print  March-23-12 3:01:21 PM									Page 4
Work Order ID: 82188			2188*				-		
Parent Item: D350-636-011 Parent Item Name: Skidtube LH		*□	350-636-01	1*			tart Date: 2 Start Qty: 1		Required Date: 09/04/2012 Required Qty: 1.00
D3490-3 *D3490-3* Cross Bolt Spacer	Manufactured	No		160	Each	18.0000	4 **	4	B 82016 × 4
			LG001 78800	L	oc Oty 18 18	Loc Code		www.	BBX016 x 4 .^
*D3490-1  *D3490-1  Cross Bolt Spacer	Manufactured	No		160	Each	29.0000	4 **	4	BE Infolfor
			Location LG001 62450 74875 77042 78793	<u>L</u>	29 2 4 3 20	Loc Code			\$ 81940 *4 - -
*AI S4-1032-225	Purchased	No	76773	220	Each	969.0000	38 <b>**</b>	38	SP 12/04/21
			Location ST281   2 269 108696 110768 118386 118966 120671 ST282 120410 120451	<u>1.</u>	936 146 62 55 68 605 33 20	Loc Code			

W/O:			W	ORK ORDER CHANG	ES		•	•
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								£.
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA: _	Date: _	
	Re	esolution:	Dispositi	on:	_ QA: N/C CI	osed:	Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCF	<b>(</b> )		
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B	Verificatio		Approval
	0.2.	Section A	Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
				·				

Picklist Print  • March-23-12 3:01:21 PM										Page 5
Work Order ID: 82188			2188*							
Parent Item: D350-636-011		*[	350-636-0°	11*						
Parent Item Name: Skidtube LH							Start Date: Start Qty:	: 23/03/2012 : 1.00	Required Date: Required Qty:	
D3793-3 *D3793-3* Wearshoe	Manufactured	No		230	Each	24.0000	* <b>*</b>	1	D 12	404/21
			Location	<u>L</u>	oc Qty	Loc Code				
			FP001 80434		12 12				_	
			FP002		12				_	
			78935		12					
AN8C35A	Purchased	No		230	Each	62.0000	1	1		
*AN8C35A*							**	(	DP) 14	04/21
			<b>Location</b>	L	e Oty	Loc Code				
			FP002		61				_	
			115960 117834		1 8			- Contract	_	
			118286		52			=		
			ST346		1				_	
			114442 115188		0					
			115960		1				_	
D3793-1	Manufactured	No		230	Each	16.0000	1	1	_	
*D3793-1* Wearshoe							**	<del>/-</del>	B 14	15/140
			Location	<u>Lo</u>	c Qty	Loc Code				
			FP001 <b>31</b> 77029		16 4			<del></del>	-	
			78901		12				-	•
			82171~							
			V-1 / 1							

W/O:			W	ORK ORDER CHANGI	ES		,	•			
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								•			
	:										
						4					
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	R: Yes No DQA: Date:					
	R	esolution:	Dispositio	n:	QA: N/C Cl	osed:	Date: _				
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCR	3)					
DATE	STEP	P Description of NC Section A		Corrective Action Section		Verification	Approval	Approval			
DAIL			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
				· · · · · · · · · · · · · · · · · · ·							
	-			·							

March-23-12 3:01:22 PM											Page 6	
Work Order ID: 82188	*82188*											
Parent Item: D350-636-011 Parent Item Name: Skidtube LH		*D350-636-011*						itart Date: Start Qty:	23/03/2012 1.00	Required Date: 09/04/2012 Required Qty: 1.00		
D3488-041 *\(\bar{D}\)3488-\(\Omega\)41* Blade Fitting Assembly, LH	Manufactured	No			230	Each	15.0000	**	1	6	1404/23	
			<u>Locati</u> FP002	0n 75056 61689 75056 77021	<u>L</u>	15 1 6 8	Loc Code			- 		
D3794-3 *D3794-3* Gasket	Manufactured	No		.,,,,,	230	Each	29.0000	1 <b>**</b>	1	(SP)	2/04/23	
			<u>Locatio</u> FP002	74530 78895 80436	<u>L</u>	29 2 3 24	Loc Code			 	/	
*AN6C44A* BOLT	Purchased	No		·	230	Each	95.0000	4 <b>**</b>	4 4	(P)	12/04/23	
			<u>Locatio</u> FG	170143 103964	. <u>L</u> a	2 2	Loc Code		1	-	, ,	
			ST343	120143 120465 120641 121013	,	93 25 27 21 20			3	- - - -		

	oopas								
W/O:		1	W	ORK ORDER CHANG	ES			ø	•
DATE	STEP	PR	OCEDURE CHA	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									ı
Part No:		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ			
Resolution:			Dispositio	n:	_ QA: N/C C	losed:	Date: _		
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCI	7)	<del></del>		
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign	Verific Secti		Approval Chief Eng	Approval QC inspector
			Chief Eng	Chief Eng	Date				

Picklist Print March-23-12 3:01:22 PM										Page 7
Work Order ID: 82188	_ · · · · · · · · · · · · · · · · ·	*8	2188*							
Parent Item: D350-636-011 Parent Item Name: Skidtube LH			)350-63	6-011*			Start Date: Start Qty:	23/03/2012		d Date: 09/04/2012 ed Qty: 1.00
MS21083C8	Purchased	No		230	Each	79.0000	1	1	requir	cu Qiy. 1.00
*MS21083C8*							**	_ (	(DP)	12/04/23
			11588	185	<u>Loc Oty</u> 1 1	Loc Code		~77		
			ST303 11588 11807 11930 11943 11963	7 9 6	12 0 1 2 7 2					
			ST304 — 12014 12073 12101	1	66 16 25 25					
D3536-25 *D3536-25* Gasket	Manufactured	No		230	Each	14.0000	**	1	(A)	12/04/23
			Location FP002 813 78902		14 14	Loc Code			_	
*D3631-1 *D3631-1* Washer	Manufactured	No		230	Each	291.0000	8 **	8	(P)	12/04/23
			Location FG 81874 ST072 68062 75548		100 100 191 2 189	<u>Loc Code</u>				

Shop Packet Print

Page 7

March-23-12 3:01:22 PM

N/O:			W	ORK ORDER CHANG	ES				•			
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector			
								•				
				·								
Part No:		PAR #:	Fault Cate	<b>A:</b>	Date:							
Resolution:			Disposition	on:	QA: N/C C	QA: N/C Closed: Date:						
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NCF	<b>R</b> )						
DATE	STEP	Description of NC	B . *a * . 8	ion B	- verification			Approval				
	01.61	Section A	Initial Chief Eng	Action Description Chief Eng	Date		tion C Chief Eng		QC Inspector			
							•					
	1											
							· · ·					
		· · · · · · · · · · · · · · · · · · ·										
						- Anna de la company de la com						

121255

230

230

NAS1149C0332 Purchased AN960C10L No \*AN960C101 \* washer D2745 Manufactured No

Bushing **Location** FP001 69529

210 12/04/23 PD 12/04/23 Loc Qty Loc Code 100 100 12 76142 1 78597 10

Each

Each

0.0000

112.0000

\*\*

\*\*

38

\*D2745\*

Dail Aci	Uspace	Llu							•					
W/O:			WC	RK ORDER CHANG	ES				,					
DATE	STEP	PRO	PROCEDURE CHANGE By						Approval QC Inspector					
									•					
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	NCR: Yes No DQA: Date: _								
	Re	esolution:	Disposition	1:	QA: N/C Cld	Date: _								
NCR:	· ·		WORK ORDER NON-CONFORMANCE (NCR)											
	STEP	<b>Description of NC</b> Section A		on B	Verification Approval			Approval						
DATE			<b>Initial</b> Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector					
•														
	!				,		,							
			1 1		Ī	1								

Picklist Print March-23-12 3:01:22 PM						Page 9
Work Order ID: 82188  Parent Item: D350-636-011  Parent Item Name: Skidtube LH			2188* 0350-636-0 <i>1</i>	11*	<b>Start Date:</b> 23/03/2 <b>Start Qty:</b> 1.00	Required Date: 09/04/2012  Required Qty: 1.00
*AN3C5A *AN3C5A*	Purchased	No		230 Each	1,320.000 34 3	4 34 D cz/04/23
			Location  FP001	Loc Oty  7  7  1313  28  13  7  2  23  740	Loc Code  [	<del>7</del>
D3537-1 *D3537-1* Wearpad	Manufactured	No	1210168	500 230 Each	87.0000 3 3 **	3 B @ 1404/2
			Eocation FP001 83254 79833 79835 FP002 69817	Loc Oty  82 28 54 5	Loc Code	
*NAS1149C0832R *NAS1149C0832 WASHER	Purchased	No	0,017	230 Each	301.0000 1 1	OP 12/04/13
			Location ST297	Loc Oty 301 301	Loc Code	

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
							•							
						, a.g., w								
·														

Part No:		_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: _	<del></del>
	Resolution:		Disposition:	QA: N/C Closed		Date: _	<u>-</u> .

	WORK ORDER NON-CONFORMANCE (NCR)										
	Description of NC		Corrective Action Section B	Verification	Approval	Approval					
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
	STEP	STEP Description of NC	STEP Description of NC Section A Initial Chief Eng	STEP  Description of NC Section A  Initial Chief Eng Corrective Action Section B  Action Description Chief Eng	STEP Description of NC Section A	STEP Description of NC Section A	STEP Description of NC Section A Corrective Action Section B Initial Action Description Chief Eng Chief En				

Picklist Print March-23-12 3:01:22 PM					Page 10
Work Order ID: 82188		*82188*			
Parent Item: D350-636-011 Parent Item Name: Skidtube LH		*D350-636-	N11*	<b>Start Date:</b> 23/03/2012 <b>Start Qty:</b> 1.00	Required Date: 09/04/2012 Required Qty: 1.00
*AN3C6A* BOLT	Purchased	No	230 Each	571.0000 4 4 **	OP) 12/04/23
NAS1611-013 *NAS1611-013* o-Ring	Purchased	Location FP001  111982 ST351  111982 116419 116549 116704 117619 117688 117872 118422 119449 120423 120693	Loc Otv  1 1 570 2 23 2 12 10 1 5 13 21 81 400 230 Each	132.0000 8 8 8 ** \$	P 1404/23
		Location FP001 116582 117291 117887 119623 120910 12116004	Loc Oty  132  5  2  53  36  36	Loc Code	

Duitho	oopaoo								
W/O:			WC	RK ORDER CHANG	ES			•	
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									1
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	<b>A</b> :	_ Date: _	<u> </u>
	Resolution:		Disposition	n:	_ QA: N/C C	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	<b>?</b> )			
	1	Description of NC		Corrective Action Section		VARITICS			Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Approval Chief Eng	QC Inspector

March-23-12 3:01:23 PM											Page 11
Work Order ID: 82188		*8	218	A*							
Parent Item: D350-636-011 Parent Item Name: Skidtube LH				)-636-(	N11*			Start Date: 1 Start Qty:			Date: 09/04/2012
D3535-25 *D3535-25* Wearshoe	Manufactured	No			. 230	Each	17.0000	1 **	1		1404/23
			Locati FP001 FP002	91357 62233 80331 77617	<u>L</u>	14 1 1 13 3 3	Loc Code				
D3794-1 *D3794-1* Gasket	Manufactured	No		77017	230	Each	22.0000	1 <b>**</b>	1	ØP)	12/04/23
			Location FP002	75042 80435	<u>Lo</u>	22 10 12	Loc Code				
*M\$21043-6 *M\$21043-6*	Purchased	No			230	Each	797.0000	4 <b>★★</b>	4	(P)	12/04/23
•			Location	<u>on</u>	<u>Lo</u>	c Oty	Loc Code				
			FG			20				_	
				103693		20					
			ST301	112314		777 71				_	
				117887		6				_	
				118384		200				_	
				120308		500				_	
				118384							

March-23-12 3:01:23 PM

Shop Packet Print

Page 11

W/O:			WC	ORK ORDER CHANG	GES			<del></del> -		
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										•
									- // -	
Part No	• •	PAR #:	Fault Cate	gory:	NCI	R: Yes I	No DQ	A:	_ Date: _	·
	Re	esolution:	Dispositio	n:	QA	N/C Clo	sed:		Date: _	<del></del>
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR				
DATE		Description of NC		ction B		Verific	ation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
			·							

Picklist Print  • March-23-12 3:01:23 PM						<del></del>				Page 12
Work Order ID: 82188		*A	2188*							
Parent Item: D350-636-011										
Parent Item Name: Skidtube LH		"17	)350-636-C	)11"		Sta	nt Datas	23/03/2012	D	D-4 00/04/2012
							art Qty:			Date: 09/04/2012 d Qty: 1.00
D3493-1	Manufactured	No		250	Each	62.0000	2	2	/	0>
*D3493-1* Washer							**		23	
			<b>Location</b>	<u>La</u>	c Qty	Loc Code				
			ST050		62					
			70697		2					
			77573		20				_/	
MS21083C8	Purchased	No	78835	350	40	70.0000		7883	<u> </u>	
	Putchaseu	140		250	Each	79.0000	2	2	~	9
*MS21083C8*							**		23	12/04/2
			<b>Location</b>	Lo	e Oty	Loc Code				,
			FP002		1					
			115884		1				-	
			ST303		12					
			115884		0					
			118077		1				_	
			119309		2				_	
			119436 119638		7 2				_	
			ST304						<u>·</u>	
			120142		66 16				_	
			120731		25					
			121011		25	•		1210	$\overline{u}$	10

121011

	. Johns										
W/O:			W	ORK ORDER CHANGE	S			•	•		
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector		
	,								*		
Part No		PAR #:									
	R	esolution:	Disposition: Q/								
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)					
	g/K"	Description of NC		Corrective Action Section	n B	Verific	ation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	&   Section		Chief Eng	QC Inspector		

Picklist Print  March-23-12 3:01:23 PM								Page 13
Work Order ID: 82188  Parent Item: D350-636-011  Parent Item Name: Skidtube LH			2188* )350-636-0	11*		Start Dat	te: 23/03/2012 ty: 1.00	Required Date: 09/04/2012 Required Qty: 1.00
*AN8C21A *AN8C21A* BOLT	Purchased	No		250	Each	67.0000 <b>**</b>	2 2	y B
NAS1515H3L * *NAS1515H3L *	Purchased	No	Location ST343 118758 120094 120872 121067	<u>L</u> 230	67 5 38 4 20 Each	Loc Code  172.0000 **	121067	1 1 12/04/23
WASHER			Location FG 102472 ST277 118686 119438 120072 120360	<u>L</u> .	40 40 132 3 1 32 96	<u>Loc Code</u>		12/07/25.
D2741 *D2741* Blade, 350 Skidtube	Manufactured	No	120300	250	Each	33.0000	1 1 0	JB 12104/22
			Location ST ST466 71856 76984	<u>Lo</u>	-10 43 1 32	<u>Loc Code</u>	7698	

W/O:			WC	RK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
		·							as ·
								-	
Part No	:	PAR #:	Fault Cate	Jory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	Re	solution:	Disposition	n:	_ QA: N/C C	losed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCI	R)			
		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector

Picklist Print

· March-23-12 3:01:23 PM

Page 14

Work Order ID: 82188

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

\*82188\*

\*D350-636-011\*

**Start Date:** 23/03/2012

**Required Date:** 09/04/2012

Start Qty: 1.00

Required Qty 100

\*\*

Manufactured No

250

Each

39.0000

Loc Oty Location Loc Code ST053 39 78839 39

8 839

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector		
							,			•		
<del></del>	•											
Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	es No	o <b>DQ</b>	<b>\:</b>	_ Date: _			
		esolution:										
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)	<u> </u>					
DATE	STEP	Description of NC		tion B	- 0	Verific		Approval	Approval			
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Di	n & ite	Section	on C	Chief Eng	QC Inspector		
·												
					•							

	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
	X	i		1	D2750-041	350 SKIDTUBE ASSEMBLY, LH
•		X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
٠,			X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
•				Х	D2750-044	350 SKIDTUBE ASSEMBLY, RH
	1	1	1	1	D2739	WEB
	8	8	8	8	D2743	SPACER
	1	1	1	1	D2744	CAP
	8	8	8	8	D2745	BUSHING
	1				D2750-1	SKIDTUBE WELDMENT, LH
		1			D2750-2	SKIDTUBE WELDMENT, RH
			1		D2750-3	SKIDTUBE WELDMENT, LH
				1	D2750-4	SKIDTUBE WELDMENT, RH
j	1		1		D3488-041	BLADE FITTING, LH
		1		1	D3488-042	BLADE FITTING, RH
	4	4	4	4	D3490-1	SPACER
[	4	4			D3490-3	SPACER
- 1			4	4	D3490-5	SPACER
	8	8	8	8	D3492-041	PLUG ASSEMBLY
[	8	8			D3492-043	PLUG ASSEMBLY
[			8	8	D3492-045	PLUG ASSEMBLY
	1	1	1	1	D3535-25	WEARSHOE
, [	_1	1	1	1	D3536-25	GASKET
/F\ [	3	3	_3	3	D3537-1	WEARPAD
	8	8	8	8	D3631-1	WASHER
Γ[	1	1	1	1	D3791-1	WEARPLATE
! [	1	11	1	1	D3793-1	WEARSHOE
L	1	1	1	1	D3793-3	WEARSHOE
Æ   [	_ 1	1	_1	1	D3794-1	GASKET
	1	1	1	1	D3794-3	GASKET
_						
£	38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
	34	34	34	34	AN3C5A	BOLT
_ [	4	4	4	4	AN3C6A	BOLT
Ţ	4	4	4	4	AN6C44A	BOLT
Γ	1	1	1	1	AN8C35A	BOLT
	38	38	38	38	AN960C10L	WASHER
ZEST_	1	1	1	1	AN960C816L	WASHER
-  -	4	4	4	4	MS21043-6	NUT
	1	1	1	1	MS21083C8	NUT
	4	4	4	4	NAS1515H3L	WASHER

**GENERAL NOTES:** 

D

MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

MATERIAL: MAKE DZ/30-11-Z1-31-4 FROM DZ000-3 EXTROSION (INTIAL LENGTH ~ 120.0).
FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D2750-041-042/-043/-044 = 26.5 LBS

WELD PER DART QSI 004

INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø 0.297) FOR WEARSHOE INSERTS

FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

MINIMUM YIELD TENSILE STRENGTH = 35 KSI

MINIMUM YIELD TENSILE STRENGTH = 36 KSI

SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS-8" AFTER FINISH AND AFTER FINISH AND AFTER INSTALLATION OF INSERTS.

SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL F

SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL

F

SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 82188 MCJ

12/03/23

						1	
F	QTY (3 D3791- D3794- ADD D3 WEARS (8 PL), D3488- ADD NO	3791-1 (ZN C8- SHOF HOLES L	OTY (5) (ZN C8-1); 5 D3354-31/35 (ZN C8-1); 6 D3356-13/-35 (ZN B8-1); 1); NDER FWDJAFT SADDLE REMOVED ARDWARE OTY UPDATED (ZN B8-1); WARE UPDATED (ZN C1-8, 9, 10, 11); (ZN A6-1);	PH	08.07.16		
E	REMOV NAS15	JBBER GASKE 'E QTY (38) NA	SS STEEL WEARPLATES; TS: CHANGE INSERTS; ADD D3631-1; S1515H3L; REMOVE QTY (10) E D2741, QTY (2) AN960C816; 1083C8	CB	07.05.17		
D	ADD HO	DLES AND SHA ORATE DEO 9	CERS FOR APICAL FLOATS; 0133/9157	РН	06.01.05	Γ	
С	ADD D2	750-3/D2750-4	INCORPORATE D2738 AND D2740	CP	98.11.18		
В	CHANG	E MS24694-S2	93 TO AN8-16A	CP	98.09.01	ŀ	
Α	NEW IS	SUE		DS	98.04.16		
REV.			DESCRIPTION	BY	DATE		
DESIGN	١	PG,	DART AEROSPACE	USA	INC.	A	
DRAWN	1	REH	PORT HADLOCK		1	^	
CHECK	ED	116	DRAWING NO.		REV. F		
MFG. A	PPR.	ALC:	D2750	s	HEET 1 OF 11		
APPRO	VED	IN	TITLE		SCALE		
DE APP	R.		350 SKIDTUBE ASSEMBLY NTS				
DATE	08.0	7.16	COPYRIGHT © 1998 BY DART AER THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OF COPED OF COMMUNICA	OH THE EXPARES	CONDITION THAT E' IS		

5

MITTEN PERMISSION FROM DART AEROSPACE USA IN

<b>D</b> ui 1 70	. oopaoc	Lia							
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
									,
<u> </u>									
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b> /	] A:	Date:	
		esolution:							
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip Chief Eng Chief Eng		on B Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
			Office Ling	Ondi Eng	Duto		•		
		,							

82188 D2750-041 350 SKIDTUBE ASSEMBLY, LH D2750-042 350 SKIDTUBE ASSEMBLY, RH DART AEROSPACE USA, INC.
PORT HADLOCK, WA DESIGN DRAWN DRAWING NO. CHECKED REV. F D2750 MFG. APPR. SHEET 2 OF 11 TITLE APPROVED SCALE 350 SKIDTUBE ASSEMBLY

COPYRIGHT E 1998 BY DART AEROSPACE USA, INC.
THIS DOCUMENT AE PROVIDE AND CONFECULTURA HOUS SHIPPLES OF THE FERRESS CONCINON TO NOT TO BE USED OF AN IN PURPOSE OF CONFECULTURA HOUST AND TO A PROVIDE AND PURPOSE DE APPR. NTS DATE 08.07.16

8

W/O:			W	ORK ORDER CHANG	SES			·	•	
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		**************************************					7		· · · · · · · · · · · · · · · · · · ·	*
	-									
								:		
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Y	es N	o <b>DQ</b>	<b>\:</b>	_ Date:	
	R	esolution:	Disposition	on:	QA: N/0	Clos	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP Description of Section A	Description of NC		tion B		Verific	ation	Approval	Approval	
DAIL			Initial Chief Eng	Action Description Chief Eng		n & ate	Section C		Chief Eng	QC Inspector
							•			

2 D2750-043 350 SKIDTUBE ASSEMBLY, LH D2750-044 350 SKIDTUBE ASSEMBLY, RH DESIGN DART AEROSPACE USA, INC.
PORT HADLOCK, WA DRAWN DRAWING NO. D2750 CHECKED REV. F MFG. APPR. SHEET 3 OF 11 APPROVED TITLE SCALE 350 SKIDTUBE ASSEMBLY NT.

COPYRIGHT 6 1998 BY DART AEROSPACE USA, INC.
THE COMMENT OF MAY THE ARROSPACE USA OF THE MAY THE ARROSPACE USA.

THE COMMENT OF THE MAY THE MAY THE ARROSPACE USA.

THE COMMENT OF THE MAY THE ARROSPACE USA.

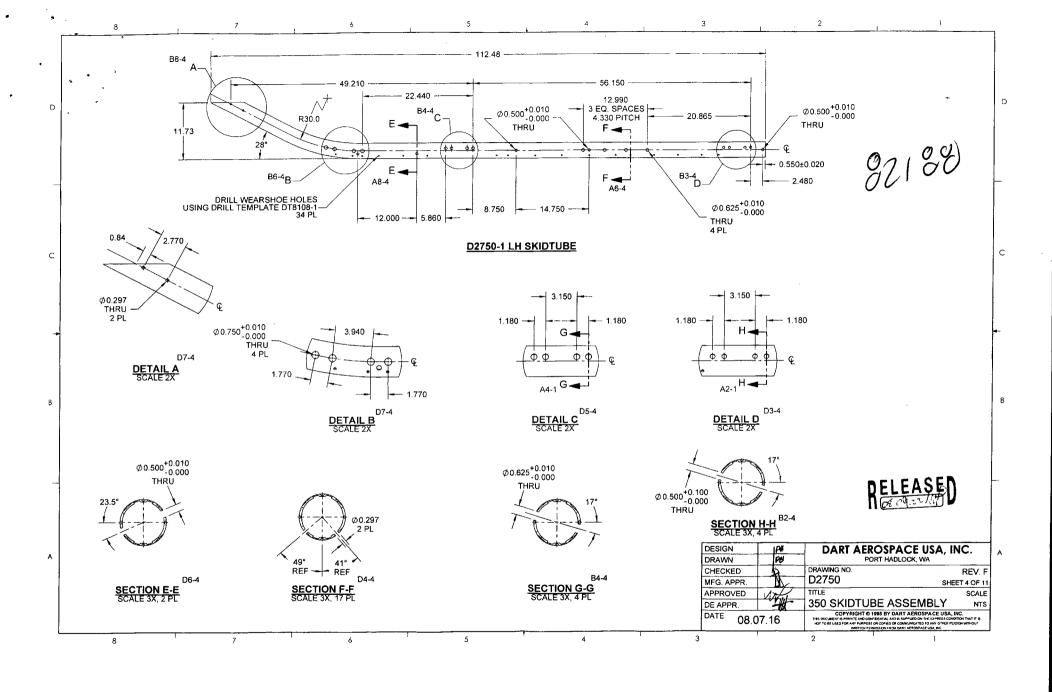
THE COMMENT OF THE MAY THE ARROSPACE USA.

THE COMMENT OF THE MAY THE MAY THE ARROSPACE USA.

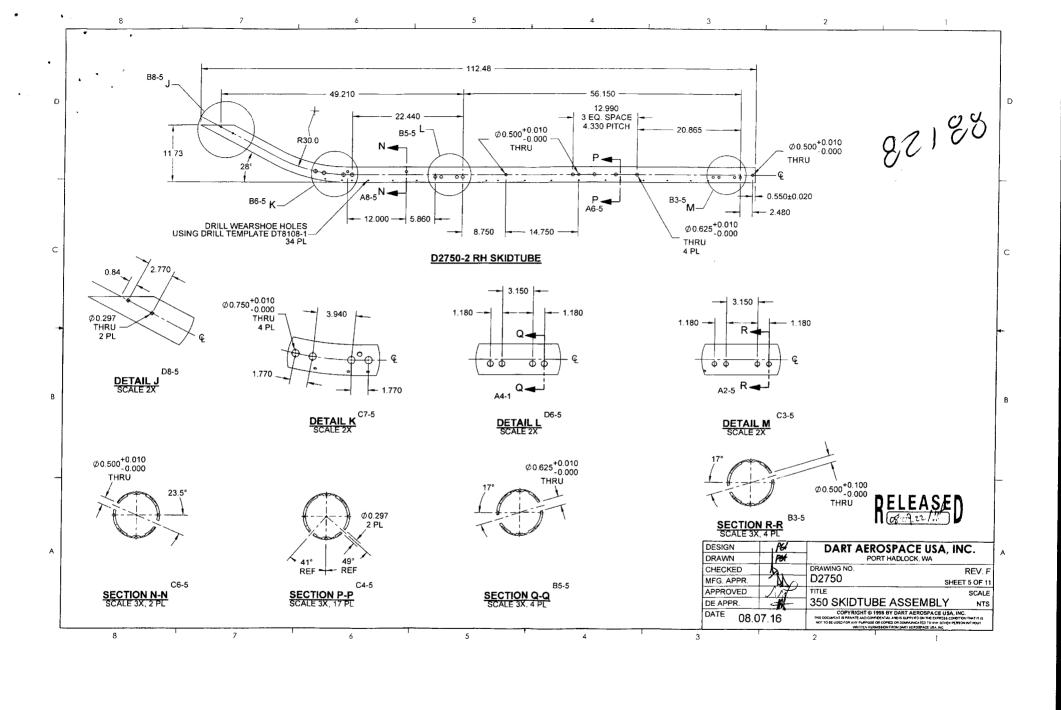
THE COMMENT OF THE MAY THE MAY THE ARROSPACE USA.

THE COMMENT OF THE MAY DE APPR. NTS DATE 08.07.16 8 3

Dail Ac	ospace	Liu							
W/O:			W	ORK ORDER CHAN	GES				
DATE	STEP	PR	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
									•
		·							
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	on:	QA: N/C (	Closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ction B	Verific	cation	Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng			ion C	Chief Eng	QC Inspector
									1



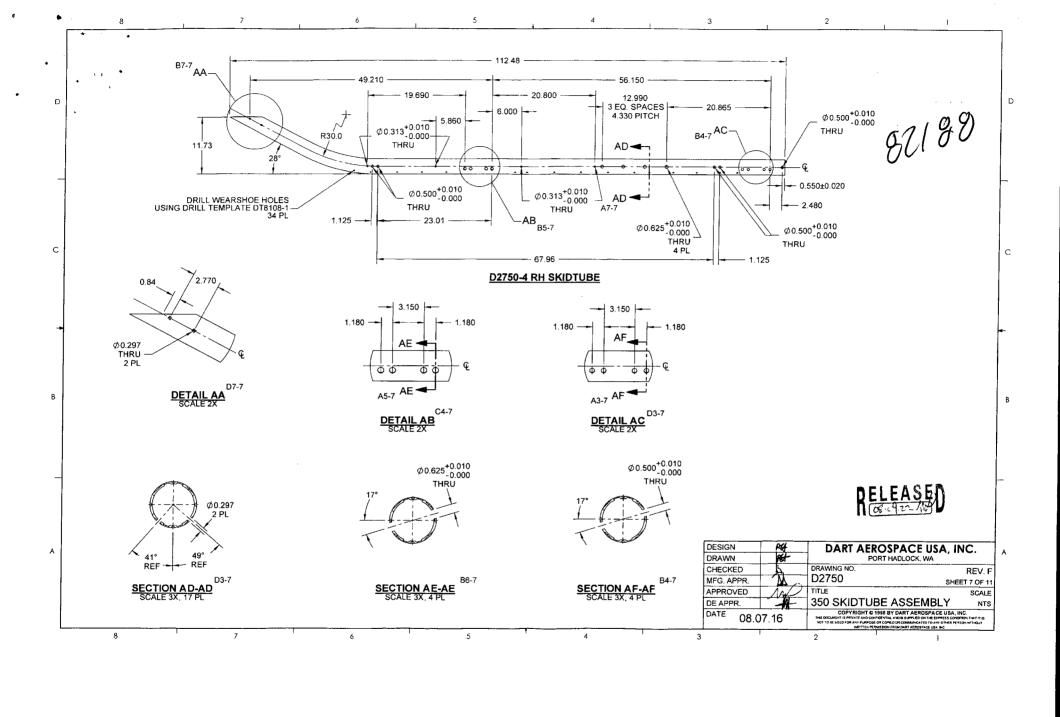
-u	oopaoo	, Elu								
W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
							-			
Dowl No.		DAD #	Fault Oak		NOD: Y				Doto:	
Part No		PAR #:								
	Resolution:			n:			d:		Date:	
NCR:		\		ER NON-CONFORMA	ANCE (N	CR)				
DATE	STEP	Description of NC	Corrective Action Initial Action Descript		on B	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Verific		Approval	Approval
	<b>U.L.</b>	Section A	Chief Eng	Action Description Chief Eng		n & ate	Section C		Chief Eng	QC Inspector
•										
							·			
								•		
			1 1		ı					i '



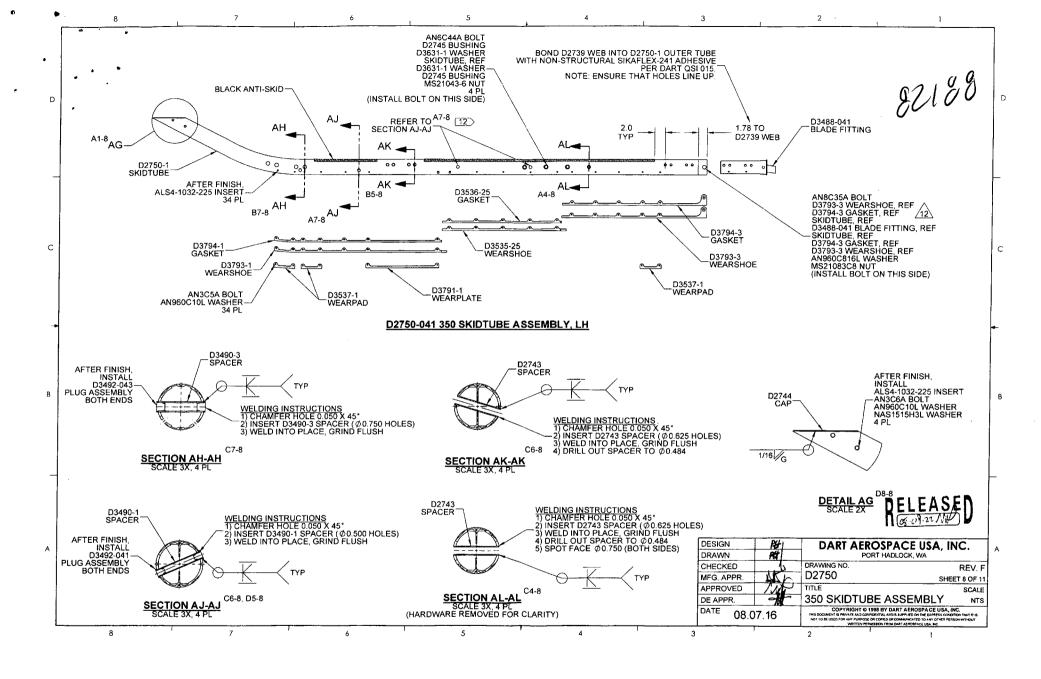
Dart Aerospace L	Ltd
------------------	-----

W/O:		WORK ORDER CHANGES											
DATE STEF		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	<b>A</b> :	Date:							

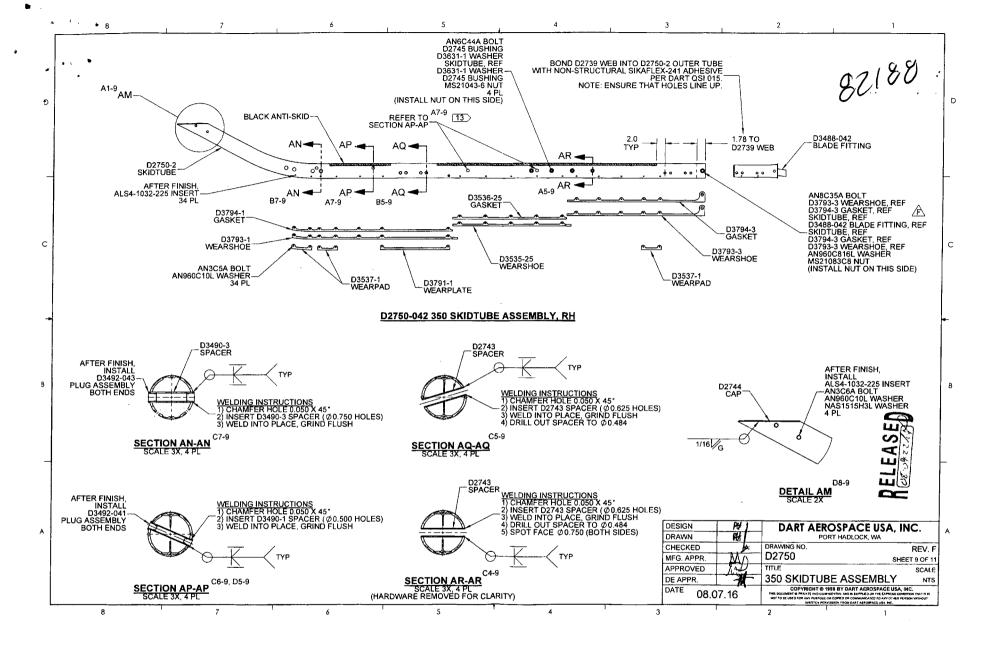
	Res	olution:	Dispositio	n:	QA: N/C Clos	sed:	Date:		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)		· · · · · · · · · · · · · · · · · · ·		
		Description of NC		Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto	
					4 3 5				
					i i				
	+ +								



	. oopaoo								
W/O:			WC	RK ORDER CHANG	ES				<u> </u>
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
						·			·
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	<b>4</b> :	_ Date: _	
	Re	esolution:	Disposition	1:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)			-
DATE		Description of NC			ion B	Verific	ation	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Section		Chief Eng	QC Inspector
							·		
							:		
	1 1		1		ı	I		i	'

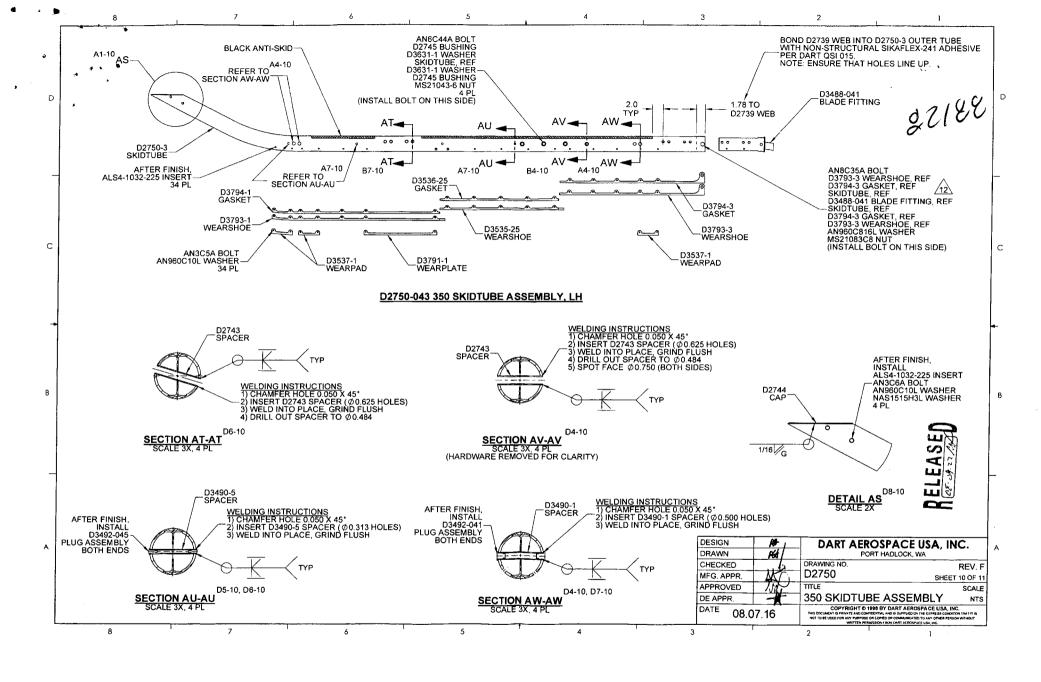


-411710	. oopaoo								
W/O:			WC	RK ORDER CHANG	ES				·•
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,
					· · · · · · · · · · · · · · · · · · ·				
							<u> </u>		
Part No		PAR #:							
	Re	solution:	Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
D.47F		EP Description of NC Section A			on B	Verific	cation	Approval	Approval
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	ion C	Chief Eng	QC Inspector
									·
								-	
	1 1		1		l			1	1



Dart Aeros	pace Ltd
------------	----------

									4
W/O:									
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·			
			·						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	s No DQ	A:	_ Date: _	
	Resolution: Disposition: QA: N/C Closed:							Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
		Description of NC	Corrective Action			Verific	ication Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Secti		Chief Eng	QC Inspector
				·		e'			
·									
							,		

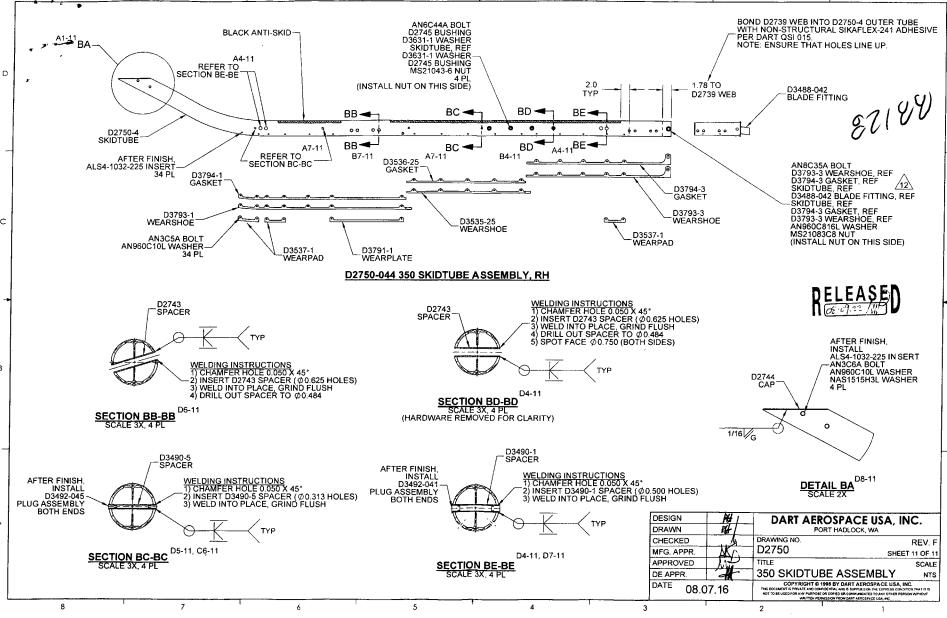


Dart	Aer	ospa	ace	Ltd
------	-----	------	-----	-----

W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	•Approval QC inspector
							•
		·					

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	<b>l:</b>	Date:

	WORK ORDER NON-CONFORMANCE (NCR)						
	Corrective Action Section B				Verification	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B  Initial Action Description	STEP Description of NC Corrective Action Section B  Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section C Section C	STEP Description of NC Corrective Action Section B Verification Approval Chief Eng



D

8

Dart Aerospace L	td
------------------	----

	oopao.	o Eta								
W/O:			WO	RK ORDER CHANGE	S	· · · · · · · · · · · · · · · · · · ·	···			
DATE	STEP	PF	ROCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval OC Inspector
					·			,		
Part No:	· ·	PAR #:	Fault Categ	jory:	NCR:	Yes N	lo <b>DQ</b>	<b>A</b> :	_ Date: _	<u> </u>
•	R	esolution:	solution: Disposition:			VC Clos	sed:		Date: _	<del></del>
NCR:		. ,	WORK ORDE	R NON-CONFORMA	NCE (	NCR)			,	
		Description of NC			Section B Verifica			ation	tion Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
						J. Pari			·	
							,·			
		*								
		·					·			
				· · · · · · · · · · · · · · · · · · ·						

NO. **186** 

# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: <u>Barclay L//iott</u> Tob number: 82/89	
Part number: \$\delta 350 - 636 - 012	
Description: Skid Hube	
Welding Process: Tig[/ Mig[]	
Base materiel: Alum	
Current: AC O DC ]	

# TEST REQUIREMENTS AND RESULTS

	•
Visual: Penetration:	pass[ fail[ ] pass[ fail[ ]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier Band Alwal Welder Barlay Ellion	Date of Test Coupon 12-04-03  Date of Test Coupon 12-04-03

The above named individual is qualified in accordance with AWS D17.1.2001 to weld